

27

Date: Tuesday, 6/19/2007 2:19:14 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEB
Job Number	32989		
Estimate Number	10498		
P.O. Number	N/A	Part Number	D2739
This Issue	6/19/2007	Drawing Number	D2739 REV C
Prsht Rev.	NC	Project Number	N/A
First Issue	N/A	Drawing Revision	C
Previous Run	32874	Material	N/A
Written By		Due Date	7/1/2007
Checked & Approved By	HJOT.06-20	Qty:	4
Comment	Est Rev: C 02.11.28 Reformat KJ Est Rev: D 06-03-21 As Per Rev C JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	D26005108	Extrusion 'I Beam' thin	
Comment:	Qty.: 1.0000 Each(s)/Unit	Total : 4.0000 Each(s)	
	Extrusion 'I Beam' thin		
Pick:			
Qty	Part Number	Description	Batch
1	D2600-5	Web	B29985 (4) 7-7-26
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
Comment:	LANDING GEAR RESOURCE 1		
	1-Cut D2600-5 to length as per Dwg D2739.		7-7-26
	2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739		
	3-Use uni-bit to open holes to finish size as per Dwg D2739.		
	4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends.		
	5-Dburr		
3.0	QC5	INSPECT WORK TO CURRENT STEP	
Comment:	INSPECT WORK TO CURRENT STEP		07/07/26
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
Comment:	HAND FINISHING RESOURCE #1		
	Acid etch and Alodine as per QSI 005 4.1		7-7-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/07/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: WEB

Job Number: 32989

Part Number: D2739

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



DS

2-9-27

(4)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock

Location: *Landing Gear*

JUL 07 07 30

(4)

7.0 QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

207/07/30

Job Completion



Job 07-07-30

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

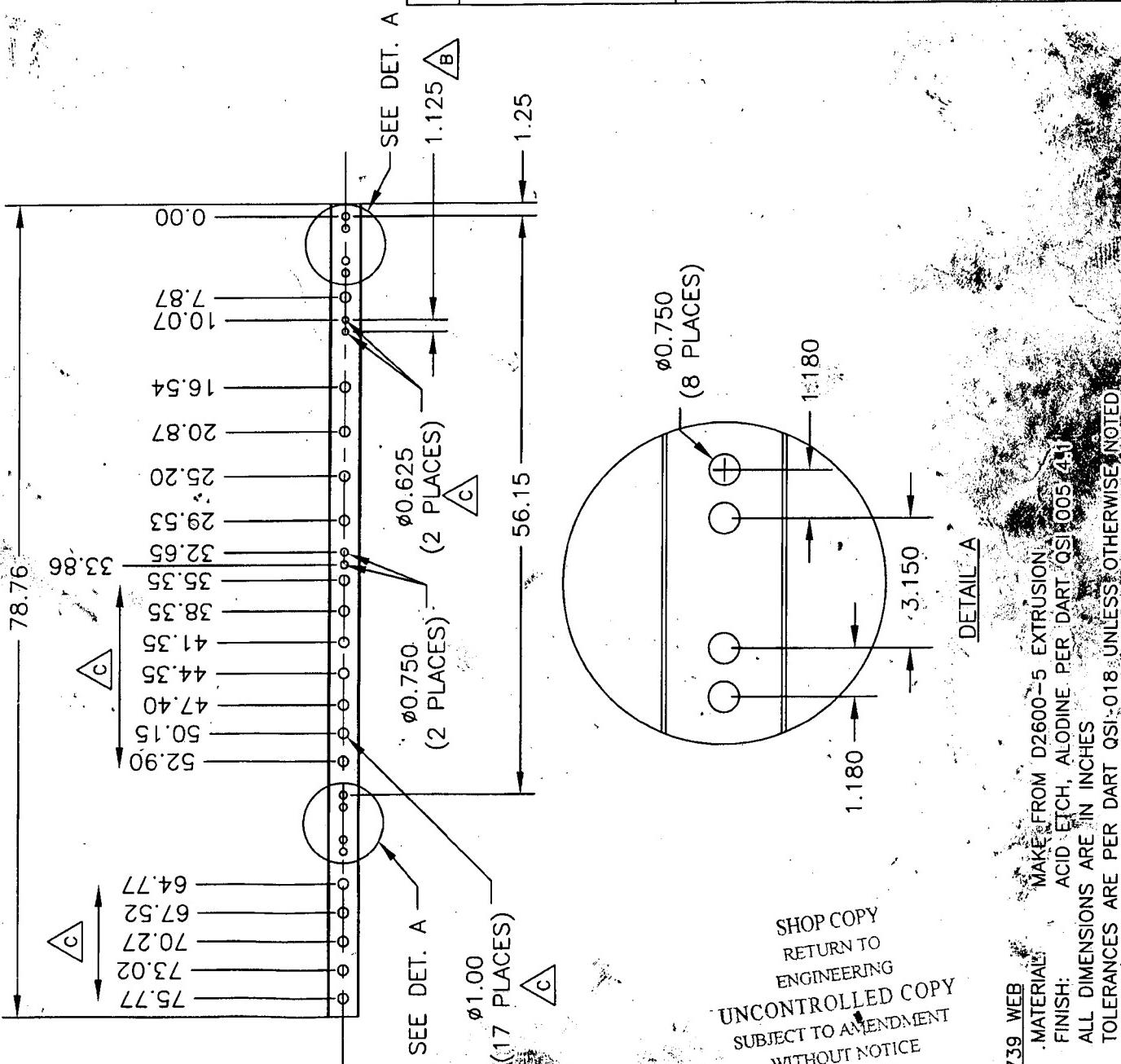
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng.	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2739	REV. C	SHEET 1 OF 1
DATE 06.01.05		TITLE WEB	SCALE 1:15	
A	98.04.16	NEW ISSUE		
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS		
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS		

RELEASER
dc-02-07 11



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO 32989

D2739 WEB

1)	MATERIAL
2)	FINISH:
3)	ALL DIM
4)	TOLERAN

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